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DART AEROSPACE LTD.	Work Order:	22209
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	814 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	CH	05.01.14	814
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: 21818	Er	05/01/27	14
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: 21801	EP	05/01/27	14
4	MV	Fixturing W/O No. 205 Fixturing Inspection last completed 05/01/27 by Er	EP	05/01/27	14
5	MV	Program Batch No. 22209 Double check by: gml	EP	05/01/27	14
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EP	05/02/03	14
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EP	05/02/03	14
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EP	05/02/03	14
9	MV	Machine keyway as per dwg D2571 & D2572	EP	05/02/03	14
10	MV	Deburr and remove all machining marks	EP	05/02/03	14
11	MV	Tumble for 20 minutes to remove sharp edges. 04.02.21	EP	05/02/03	14
12	QC1	Inspect all dimensions to dimension sheets	EP	05/02/03	14
13	QC7	Second inspection	ML	05/02/03	14
14	FP	Acid etch and alodine as per QSI 005 4.1	ML	05/02/14	14
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	ML	05/02/21	14
16	QC3	Inspect Powder Coat	CL	05/02/23	14
17	ST	Identify and Stock.	CL	05/02/23	14
18	AC	Cost / Part 148.75 121.28	SAC	05.02.24	14
19	DC	Close W/O 138.21 118.56 Inspection Level 21	CH	05.03.02	14

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	RF

RELEASED
02/10/15 RF